

ACG ship Nov 4

Work Order ID 152528***152528***

Page 1

Thursday, October 27, 2016 10:15:17 AM

Item ID: D119-646-112 **Accept** ***N900040100*** **Setup Start** ***NS1***
Revision ID: URF 15-560 **Stop** ***NS2***
Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - RH
Start Date: 10/27/2016 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 11/1/2016 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** em **Date:** 16/10/27 **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D119-646	C	OCT 27 2016							
100		0.00							
100									
DC		0.00							
Doc.Control -USB or Paperwork	Memo								
	Photocopy bluefile & type labels per PPP D119-646-112								
	CHG-003								
110	Pick Kit	0.00							
110									
Packaging		0.00							
Packaging	Memo								
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC		0.00							
Quality Control	Memo								

B152531

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 152528***152528***

Page 2

Thursday, October 27, 2016 10:15:17 AM

Item ID: D119-646-112 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-560 Stop ***NS2***
Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - RH
Start Date: 10/27/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/1/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00			DAS 28 9-89	DAS 27 9-89			
Packaging	Identify and pack for shipping as per PPP D119-646-112								
	Location: _____								
	PPP rev: _____ Sold								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00				DAS 21 9-89			NOV 02 2016
Quality Control									
						DAS 21 9-89			NOV 02 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Picklist Print

Thursday, October 27, 2016 10:15:17 AM

Page 1

Work Order ID: 152528

152528

Parent Item: D119-646-112

D119-646-112

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - RH

Start Date: 10/27/2016

Required Date: 11/1/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
12.11.05 raise to chg002 (ECN 12-675) DD verf:JLM IPP REV:C 13.03.20
raise to chg003 (ECN 13-534) DD verf:JLM IPP REV:D 14.11.25 IIN REV.C
(ECN 14-628) DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-141		Manufactured	No			110	Each	0.0000	1	1			
D119-646-141									**				
AW119 Replacement Skidtube with Standard Wearplates & Wearpads, Fits LH & RH													
D119-646-311		Manufactured	No			110	Each	4.0000	1	1			
D119-646-311									**				
Ground Handling													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST636a			4					
					130012			4					
D3883-2		Manufactured	No			110	Each	2.0000	2	2			
D3883-2									**				
Saddle, Outside RH													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST404			2					
					149623			2					
D3884-2		Manufactured	No			110	Each	2.0000	2	2			
D3884-2									**				
Saddle, Inside RH													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST404			2					
					150388			2					

B/S2531

DAS 28 9-89

DAS 6 28 9-89

OCT 20 2016

DAS 6 28 9-89

OCT 28 2016

OCT 28 2016

DAS 6 28 9-89

2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Thursday, October 27, 2016 10:15:17 AM

Page 2

Work Order ID: 152528

152528

Parent Item: D119-646-112

D119-646-112

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - RH

Start Date: 10/27/2016

Required Date: 11/1/2016

Start Qty: 1.00

Required Qty: 1.00

D2652 Manufactured No 110 Each 220.0000 16 16

D2652

Bushing

**

DAS
OCT 28 2016
9-89

DAS
28
9-89

DAS
27
9-89

Location Loc Qty Loc Code

FG 44
31985 44
ST009 176
149828 176

AN3C50A Purchased No

AN3C50A

Bolt

DAS
27
9-89

110 Each 47.0000 8 8

**

DAS
6
9-89 OCT 28 2016

DAS
28
9-89

Location Loc Qty Loc Code

ST346 47
m135950 17
m135964 30

AN4C6A Purchased No

AN4C6A

Bolt

DAS
27
9-89

110 Each 333.0000 12 12

**

DAS
6
9-89 OCT 28 2016

DAS
28
9-89

Location Loc Qty Loc Code

FG 14
103344 4
121657 10
OVER002 220
m135470 145
m135603 75
ST345 99
m135297 10
m135470 89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

Thursday, October 27, 2016 10:15:17 AM

Page 3

Work Order ID: 152528

152528

Parent Item: D119-646-112

D119-646-112

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - RH

Start Date: 10/27/2016

Required Date: 11/1/2016

Start Qty: 1.00

Required Qty: 1.00

MS21250-05-006

Purchased

No

110

Each

130.0000

8

8

MS21250-05-006

BOLT

OCT 28 2016
DAS 6 28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

124291

10

over006

60

M131379

30

M133234

30

ST295

60

M125646

16

M131620

20

M133606

24

8

NAS1149C0332R

Purchased

No

110

Each

4,578.000

8

8

NAS1149C0332R

WASHER

OCT 28 2016
DAS 6 28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

118

m135274

118

GA

86

m133284

86

ST260a

3000

m135466

1000

m135672

1000

m135948

1000

ST266

1374

m135408

674

m135766

500

m135908

200

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Thursday, October 27, 2016 10:15:17 AM

Page 4

Work Order ID: 152528

152528

Parent Item: D119-646-112

D119-646-112

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - RH

Start Date: 10/27/2016

Required Date: 11/1/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

110

Each

1,039.000

24

24

NAS1149C0432R

WASHER

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

800

m125807

427

m134676

373

ST266

239

m135544

239

NAS1149C0532R

Purchased

No

110

Each

521.0000

8

8

NAS1149C0532R

WASHER

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

60

116513

60

ST260a

300

m135390

200

m135966

100

ST266

161

m135671

161

OCT 28 2016

DAS 6 28
9-89 9-89

OCT 28 2016

DAS 6 28
9-89 9-89

Thursday, October 27, 2016 10:15:17 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

Thursday, October 27, 2016 10:15:17 AM

Page 5

Work Order ID: 152528

152528

Parent Item: D119-646-112

D119-646-112

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - RH

Start Date: 10/27/2016

Required Date: 11/1/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

110

Each

1,180.000

8

8

MS21043-3

Nut

DAS
6
9-89
OCT 28 2016

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK007

400

m135864

400

FG

80

103691

80

FP001

11

m130673

11

GA

133

m133990

133

OVER007

400

m135704

400

ST302

87

m135544

87

ST304

69

m131340

69

8

MS21043-4

Purchased

No

110

Each

727.0000

13

13

MS21043-4

Nut

DAS
6
9-89
OCT 28 2016

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

17

m132803

17

ST302

670

m135530

170

m135600

500

13

Thursday, October 27, 2016 10:15:17 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Thursday, October 27, 2016 10:15:17 AM

Page 6

Work Order ID: 152528

152528

Parent Item: D119-646-112

D119-646-112

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - RH

Start Date: 10/27/2016

Required Date: 11/1/2016

Start Qty: 1.00

Required Qty: 1.00

D2712

Manufactured No

110

Each

302.0000

12

12

D2712

Set Screw

OCT 28 2016

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

FG	50
29962	50
ST010	252
140532	9
147801	33
149148	50
149832	100
151290	50
89929	10

12

D3672-3

Manufactured No

110

Each

1,100.000

24

24

D3672-3

Washer, Phenolic

OCT 28 2016

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

FG	100
133083	52
134449	48
FP001	213
132639	213
ST049	287
149295	287
ST051A	500
151298	500

24

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									

Picklist Print

Thursday, October 27, 2016 10:15:17 AM

Page 7

Work Order ID: 152528

152528

Parent Item: D119-646-112

D119-646-112

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - RH

Start Date: 10/27/2016

Required Date: 11/1/2016

Start Qty: 1.00

Required Qty: 1.00

D3672-7

Manufactured No

110

Each

605.0000

24

24

D3672-7

Washer, Phenolic

**

OCT 28 2016

DAS 6 28
9-89 9-89

Location

Loc Qty

Loc Code

FG

40

129987

25

133986

15

ST049

65

149431

65

ST051A

500

150867

500

24

DAS 27
9-89

D3407-041

Manufactured No

110

Each

18.0000

1

1

D3407-041

Tow Ring

**

OCT 28 2016

DAS 6 28
9-89 9-89

Location

Loc Qty

Loc Code

st530

18

149195

10

151431

8

1

DAS 27
9-89

D3417-5

Manufactured No

110

Each

91.0000

2

2

D3417-5

Washer

**

OCT 28 2016

DAS 6 28
9-89 9-89

Location

Loc Qty

Loc Code

ST035

11

148700

11

ST038A

80

149255

40

151493

40

2

DAS 27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Page 8

Thursday, October 27, 2016 10:15:17 AM

Work Order ID: 152528

152528

Parent Item: D119-646-112

D119-646-112

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - RH

Start Date: 10/27/2016

Required Date: 11/1/2016

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

108.0000

1

1

D3456-1

Washer

OCT 28 2016

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST037

101

149551

1

150652

50

151938

50

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

6.0 PARTS LIST

REFERENCE ONLY

6.1 Standard Skidtubes

Item	Qty -011	Qty -012	Qty -111	Qty -112	Qty -211	Qty -212	Qty -041	Qty -141	Qty -151	Qty -241	Qty -251	Qty -311	Part Number	Description
	X												D119-646-011	STANDARD SKIDTUBE INSTALLATION WITH WEARPADS, LH
		X											D119-646-012	STANDARD SKIDTUBE INSTALLATION WITH WEARPADS, RH
			X										D119-646-111	STANDARD SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, LH
				X									D119-646-112	STANDARD SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, RH
					X								D119-646-211	STANDARD SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, LH
						X							D119-646-212	STANDARD SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, RH
	1	1					X						D119-646-041	REPLACEMENT STANDARD SKIDTUBE WITH WEARPADS
			1	1				X					D119-646-141	REPLACEMENT STANDARD SKIDTUBE WITH FULL LENGTH WEARPLATES & WEARPADS
									X				D119-646-151	WEARPLATE KIT STANDARD SKIDTUBE
					1	1				X			D119-646-241	REPLACEMENT STANDARD SKIDTUBE WITH TRAINING WEARPLATES
											X		D119-646-251	TRAINING WEARPLATES STANDARD SKIDTUBE
	1	1	1	1	1	1						X	D119-646-311	GROUND HANDLING KIT
1							1						D3887-041	STANDARD SKIDTUBE ASSY. WITH WEARPAD
20								1					D3887-043	STANDARD SKIDTUBE ASSY. WITH WEARPLATE & WEARPAD
26									1				D3847-043	FWD WEARPLATE ASSY
27									1				D3847-045	CENTER WEARPLATE ASSY
28									1				D3847-047	AFT WEARPLATE ASSY
29									5				D3847-1	WEARPAD
30									1				D3847-11	WEARPAD
31									30				AN3C5A	BOLT
32									30				AN960C10L	WASHER (OR NAS1149C0332R)
40										1			D3887-045	STANDARD SKIDTUBE ASSY. TRAINING WEARPLATE
44											1		D3849-041	FWD TRAINING WEARPLATE ASSY
45											1		D3849-043	AFT TRAINING WEARPLATE ASSY
51											16		D3904-1	WASHER
52											8		AN3C46A	BOLT
53											8		MS21043-3	NUT
60	2		2		2								D3883-1	SADDLE, OUTSIDE, LH
61		2		2		2							D3883-2	SADDLE, OUTSIDE, RH
62	2		2		2								D3884-1	SADDLE, INSIDE, LH
63		2		2		2							D3884-2	SADDLE, INSIDE, RH
64	16	16	16	16	16	16							D2652	BUSHING
65	8	8	8	8	8	8							AN3C50A	BOLT
66	12	12	12	12	12	12							AN4C6A	BOLT
67	8	8	8	8	8	8							MS21250-05008	BOLT
68	8	8	8	8	8	8							AN960C10L	WASHER (OR NAS1149C0332R)

© COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: C

Date: 13.08.16

REFERENCE ONLY**DART AEROSPACE USA, INC.****IIN-D119-646**

Page 23 of 26

Item	Qty -011	Qty -012	Qty -111	Qty -112	Qty -211	Qty -212	Qty -041	Qty -141	Qty -151	Qty -241	Qty -251	Qty -311	Part Number	Description	
69	24	24	24	24	24	24							AN960C416L	WASHER (OR NAS1149C0432R)	
70	8	8	8	8	8	8							AN960C516L	WASHER (OR NAS1149C0532R)	
71	8	8	8	8	8	8							MS21043-3	NUT	
72	12	12	12	12	12	12							MS21043-4	NUT	
73	12	12	12	12	12	12							D2712	SET SCREW	
74	16	16	16	16	16	16							D3672-7	WASHER	
75	24	24	24	24	24	24							D3672-3	WASHER	
76	8	8	8	8	8	8							D3672-7	WASHER	
80	1	1	1	1	1	1							D3407-041	TOW RING	
81	2	2	2	2	2	2							D3417-5	WASHER	
82	1	1	1	1	1	1							D3456-1	WASHER	
83	1	1	1	1	1	1							MS21043-4	NUT	
90													2	D3886-041	LUG ASSEMBLY
91													8	D2652	BUSHING
92													4	AN3C46A	BOLT
93													4	AN960C10L	WASHER (OR NAS1149C0332R)
94													4	MS21043-3	NUT

• COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: **C**
Date: 13.08.16

Work Order ID 152528

Thursday, October 27, 2016 2:27:07 PM

152528

Page 1

Item ID: D119-646-112 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-560 Stop ***NS2***
Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - RH
Start Date: 10/27/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/1/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D119-646	C					DAS 21 9-89			OCT 28 2016

100

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D119-646-112
CHG 003

CHG 001

DAS
21
9-89

See attachment

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Change Record

PAGE 1 OF 1

Part Number: D119-646-111/-112

Description: STD SKIDTUBE w/ FULL LENGTH WEARPLATES & WEARPADS, LH/RH

[illegible]